

Date: Thursday, 4/12/2007 8:44:53 AM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	31716		
Estimate Number	10530		
P.O. Number	N/A	Part Number	D2571
This Issue	4/12/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2571 REV E
First Issue	N/A	Project Number	N/A
Previous Run	31647	Drawing Revision	E
Written By		Material	N/A
Checked & Approved By	<u>AJ</u> 07.04.12	Due Date	4/30/2007
Comment	Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	Qty:	12
Um:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>25354</u> M8 07/04/25 12
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>31716</u> Double check by: <u>J.L.</u>  1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.  <u>G8/M8 07/04/25</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 M8/Sn 07/05/03
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE M8/60 07/05/C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:44:53 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31716

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/05/03

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*fel*

07/05/03

7.0 POWDER COATING

POWDER COATING



*M103706*

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*el* 07-05-07 (12)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*07/05/08 (12)*

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*JP 07/05/08 (12)*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

*07/05/08*

Job Completion



*C207/05/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31716
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440			
B	1.745	1.755		1.745	1.748	1.750	1.750			
C	3.495	3.505		3.499	3.500	3.500	3.500			
D	1.745	1.755		1.745	1.748	1.750	1.750			
E	7.990	8.010		8.002	8.002	8.002	8.002			
F	0.490	0.510		0.492	0.497	0.497	0.497			
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260			
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377			
I	0.490	0.510		0.499	0.501	0.505	0.505			
J	1.174	1.184		1.174	1.178	1.176	1.176			
K	0.558	0.578		0.565	0.563	0.564	0.565			
L	1.174	1.184		1.174	1.178	1.176	1.176			
M	1.490	1.500		1.495	1.495	1.495	1.495			
N	2.495	2.505		2.499	2.500	2.498	2.500			
O	3.869	3.879		3.872	3.873	3.872	3.872			
P	0.115	0.135		0.128	0.128	0.127	0.127			
Q	0.115	0.135		0.135	0.135	0.135	0.135			
R	0.240	0.260		0.253	0.253	0.252	0.252			
S	0.115	0.135		0.129	0.130	0.131	0.131			
T	0.178	0.198		0.188	0.188	0.188	0.188			
U	2.940	2.980		2.960	2.960	2.960	2.960			
V	0.230	0.250		0.236	0.239	0.239	0.239			
W	0.115	0.135		0.122	0.120	0.121	0.120			
X	0.308	0.313		0.311	0.311	0.311	0.310			
Y	0.760	0.765		0.765	0.765	0.765	0.765			
Z	0.352	0.372		0.365	0.367	0.362	0.362			
AA	0.470	0.530		0.500	0.500	0.501	0.500			
AB	0.615	0.635		0.630	0.629	0.625	0.625			
AC	0.053	0.073		0.063	0.063	0.063	0.063			
AD	0.240	0.260		0.249	0.250	0.250	0.250			
AE	1.375	1.395		1.386	1.387	1.384	1.387			
AF	0.115	0.135		0.135	0.135	0.135	0.135			
AG	0.240	0.280		0.260	0.260	0.260	0.260			
AH	0.240	0.260		0.253	0.253	0.255	0.255			
AI	2.000	2.020		2.002	2.002	2.000	2.001			
AJ	0.023	0.043		0.033	0.033	0.033	0.033			
Accept/Reject										

Measured by:	En	Audited by:	JL
Date:	07/04/16	Date:	07/05/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SAJ

DART AEROSPACE LTD	Work Order:	31716
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.749	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.501	3.499		
D	1.745	1.755		1.750	1.749	1.748	1.748		
E	7.990	8.010		8.000	8.003	8.003	8.004		
F	0.490	0.510		0.500	0.495	0.497	0.496		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.501	0.501		
J	1.174	1.184		1.179	1.178	1.176	1.176		
K	0.558	0.578		0.568	0.563	0.566	0.565		
L	1.174	1.184		1.179	1.178	1.176	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.498	2.497	2.498		
O	3.869	3.879		3.872	3.871	3.871	3.871		
P	0.115	0.135		0.125	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.252	0.252	0.252		
S	0.115	0.135		0.125	0.124	0.128	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.246	0.238	0.237	0.238		
W	0.115	0.135		0.125	0.119	0.119	0.121		
X	0.308	0.313		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.360	0.367	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.628	0.627	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.250	0.250		
AE	1.375	1.395		1.387	1.386	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.252	0.251	0.252		
AI	2.000	2.020		2.002	2.001	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: *RF*  
Date: *07/05/02*

Audited by: *JL*  
Date: *07/05/03*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JL</i>	<i>JLM</i>

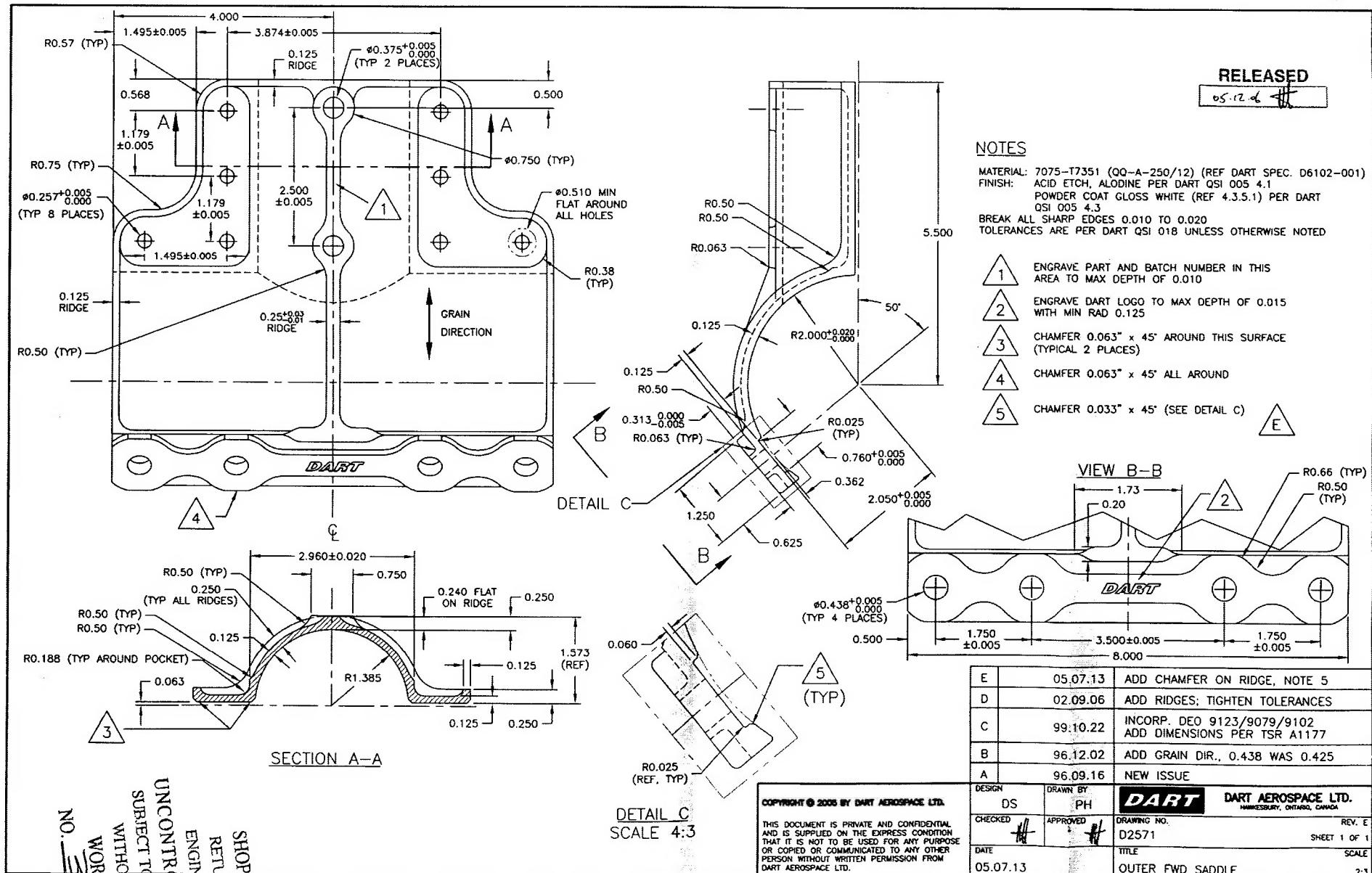
DART AEROSPACE LTD	Work Order:	31716
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Inspection Dwg: D2571 Rev. E		Page 1 of 1

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E	7.990	8.010		8.003	8.001	8.003	8.004		
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G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.379	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.503	0.503	0.502		
J	1.174	1.184		1.176	1.175	1.175	1.176		
K	0.558	0.578		0.565	0.566	0.567	0.564		
L	1.174	1.184		1.176	1.178	1.175	1.176		
M	1.490	1.500		1.493	1.494	1.494	1.496		
N	2.495	2.505		2.498	2.498	2.499	2.497		
O	3.869	3.879		3.876	3.871	3.873	3.871		
P	0.115	0.135		0.127	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
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AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.253	0.253	0.252		
AI	2.000	2.020		2.002	2.000	2.002	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EN	Audited by:	J.L.
Date:	07/05/02	Date:	07/05/03

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